

deltin 1.750-

Work Order ID 113389

113389

Page 1

Wednesday, February 12, 2014 1:19:22 PM

Item ID: PB67-43001-265 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Deltin Bushing
 Start Date: 2/11/2014 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 2/28/2014 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: mmf. Date: 14-2-12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	c

100	Hardinge CNC LATHE SMALL	0.00							
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn as per Dwg B67-43001 Dwg Rev: <u>C</u>								
	Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
02 40 14-02-16
JFC 2014-02-19

DAS
02 40 14-02-16

14-2-20 40 φ

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Required Date: 2/28/2014 Req'd Qty: 40.00 ***40*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>UZZZ</i>	0.00							
130									
Packaging	Memo	0.00				<i>40X</i>		<i>14-2-21</i>	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00						<i>14-02-21</i>	
Quality Control									
								<i>14-02-21</i>	

DAS
26
9-89

DQA: _____ Date: _____



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Training									
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Picklist Print

Wednesday, February 12, 2014 1:19:21 PM

Page 1

Work Order ID: 113389

113389

Parent Item: PB67-43001-265

PR67-43001-265

Parent Item Name: Deltin Bushing

Start Date: 2/11/2014

Required Date: 2/28/2014

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.07.19New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.750		Purchased	No			100	f	14.0000	0.175	8			

MDFI RINR1 750

DELRIN ROUND BAR 1.750

Location

Loc Qty

Loc Code

MAT039

14

125488

14

8 JFC 2014-02-19

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$\phi 1.595^{+0.000}_{-0.005}$

$\phi 1.275^{+0.005}_{-0.000}$

0.03 X 45°
CHAMFER
TYP

2.00

B67-43001-265 DELRIN BUSHING

NOTES:

- 1) MATERIAL: WHITE OR BLACK DELRIN II 150E OR ACETRON GP ACETAL
REF. DART SPEC. M-DELRIN-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 20 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO.	REV. C	
CHECKED		B67-43001-265	SHEET 1 OF 1	
MFG. APPR.		TITLE	SCALE	
APPROVED		DELRIN BUSHING	NTS	
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	09.02.27			

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